

Date: Monday, 02/03/2009 3:21:08 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PACKER
Job Number : 46225	
Estimate Number : 13598	
P.O. Number :	Part Number : D38155
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3815 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 42435	Material :
Written By :	Due Date : 09/03/2009 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-09-18 new issue DD verified by:EC	
Est Rev:B 09-03-02 rev.a as per dwg DD verified by:JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ~~M2024T30125~~ 606176 . R5 2024-T3 .125 sheet



(P10) →

Comment: Qty.: 0.1869 sf(s)/Unit Total: 3.7380 sf(s)

606176
125

~~2024-T3 .125" sheet~~

batch: 102087

FB 9-3-3

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3815

Dwg Rev: A

Prog Rev: A

FB 9-3-3

(22)

2-Deburr if necessary

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



FB 9-3-3

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



counters

Comment: SECOND CHECK

502103/03

(722)

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



x22

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD/AL

09/03/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3815-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46225</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/3	1.0	Docking inspection found that all parts (Q14x22) were made of 2024T3. 125. R.C. work order calls	<u>09.03.03</u> PER 05/04	ACCEPTABLE DEVIATION BECAUSE D3815-5 ARE USED AS SHOWN ON INSTALLATION AND NO TRENDS ARE REQ'D ON PART.	<u>09.03.03</u>	<u>09.03.03</u>	<u>09.03.03</u>	<u>9/3/3</u>
		2024 but they calls for 6061T6.125. water set operator don't catch difference.		= change w/o to match Dwg.	<u>09.03.03</u>	<u>09.03.03</u>		<u>9/3/3</u>

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 3:21:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 46225

Part Number: D38155

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-03

22X

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: 122

8/3/3

22X

SP

8.0

QC21

FINAL INSPECTION W/O RELEASE



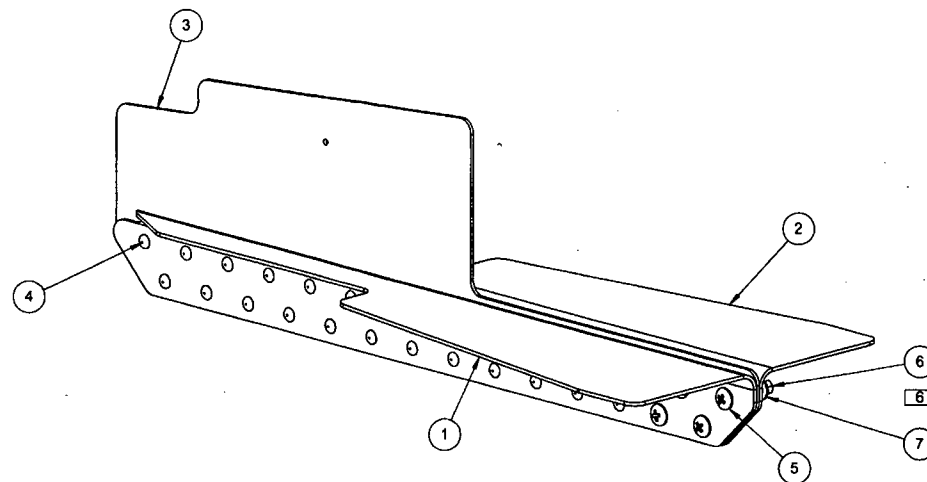
Comment: FINAL INSPECTION W/O RELEASE

09/03/05

Job Completion



MF
09-03-04



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

RELEASED
09/13/10

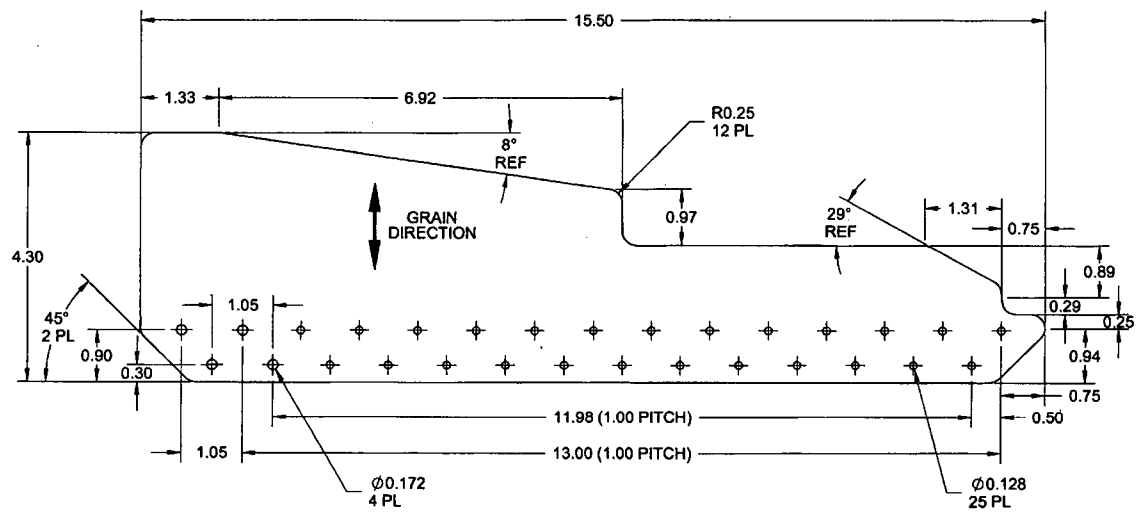
NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

*w/b
46225*

A	NEW ISSUE		08.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3815	REV. A SHEET 1 OF 5
TITLE WEB	SCALE NTS
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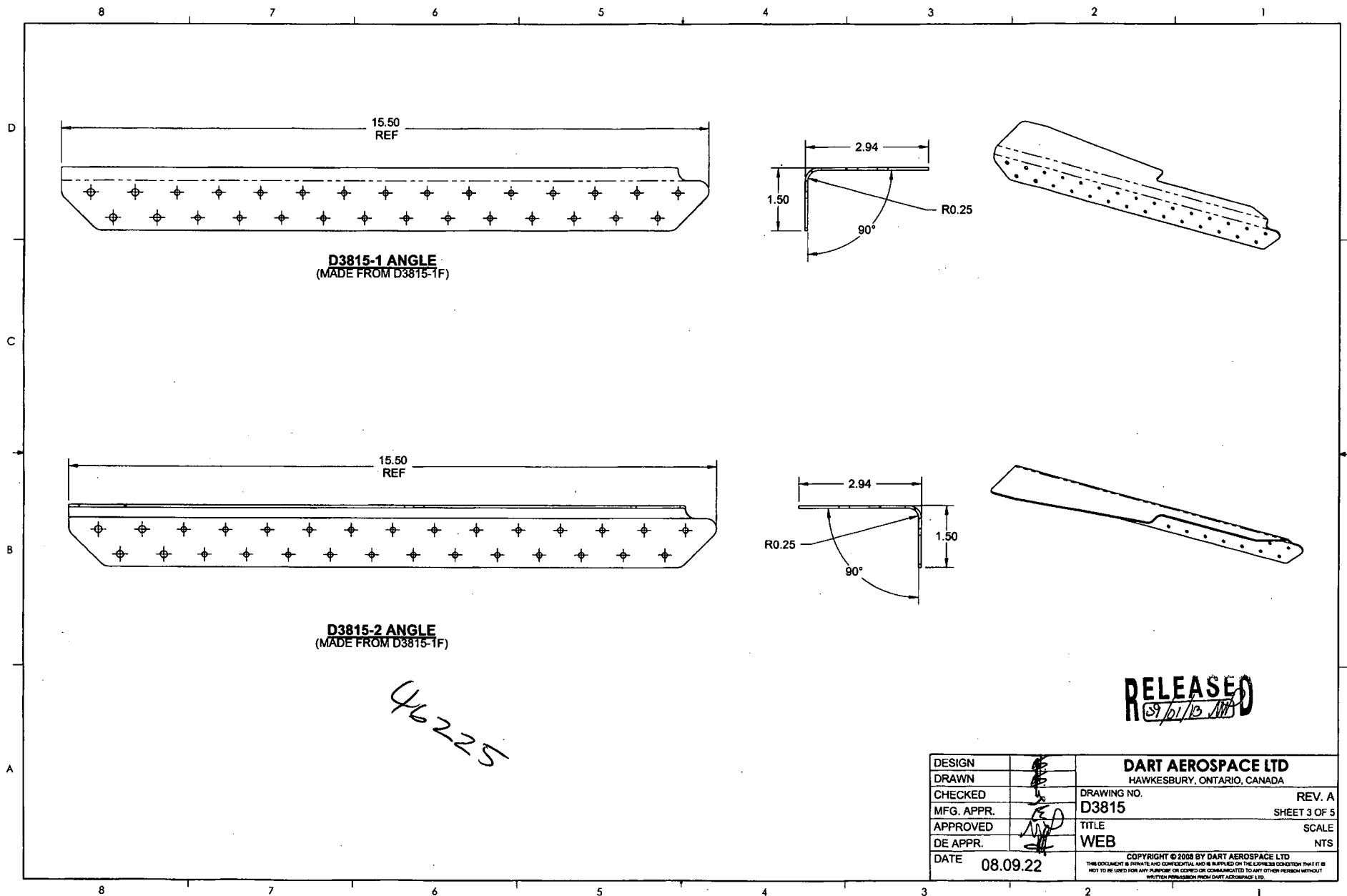
D3815-1F FLAT PATTERN

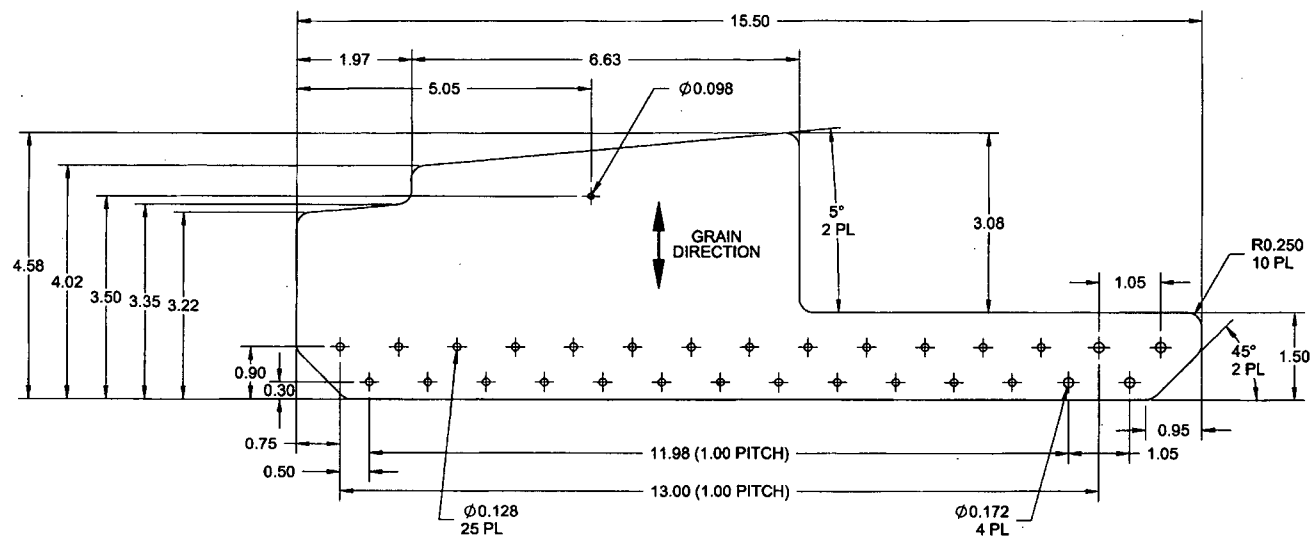
46225

RELEASED
09/13/13

- NOTES:
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.29 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3815	SHEET 2 OF 5
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D3815-3 WEB

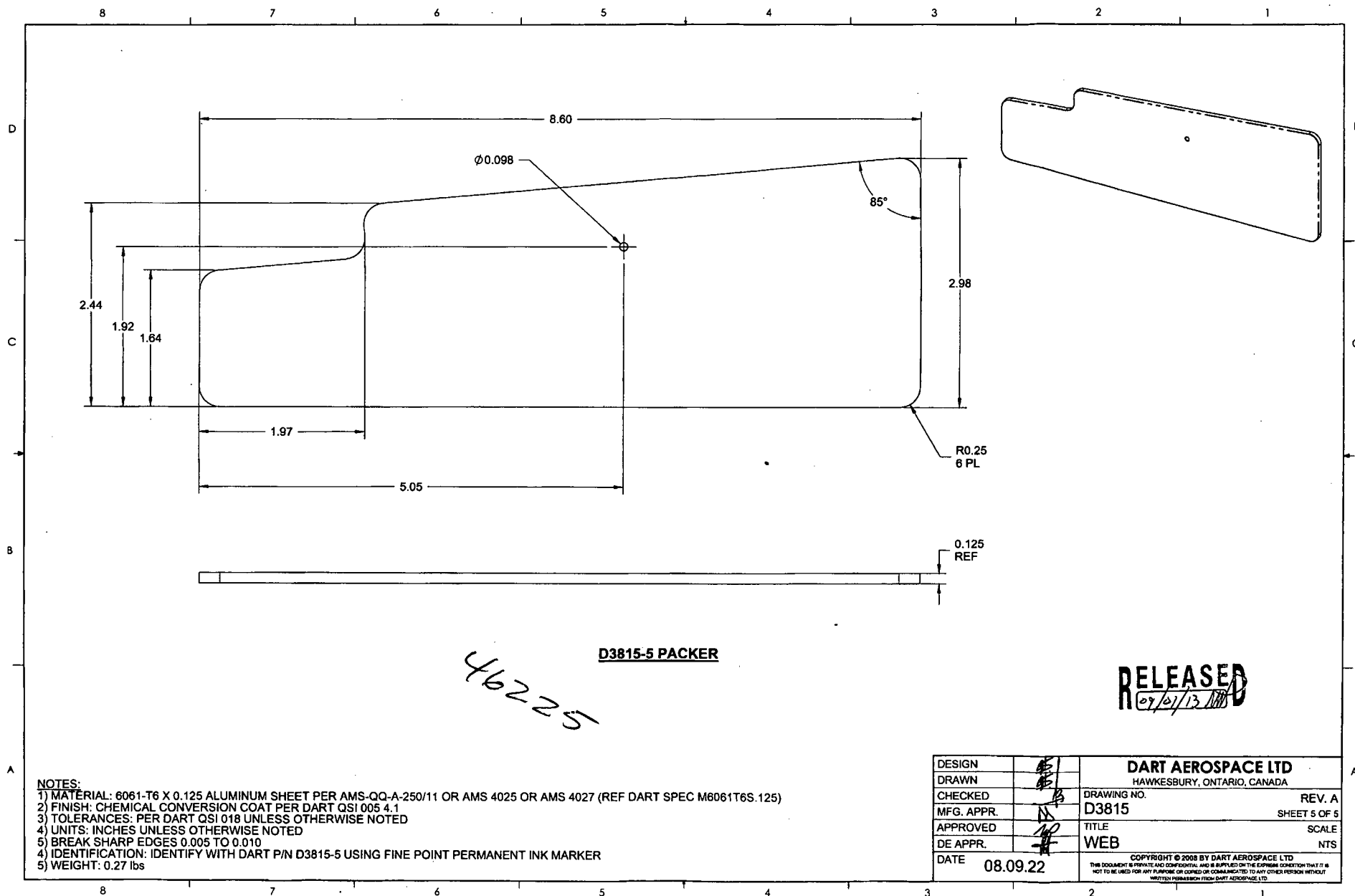
46225

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.28 lbs

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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

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MFG. APPR.		D3815	SHEET 5 OF 5
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DE APPR.		WEB	NTS
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